

Work Order ID 132079

Friday, April 24, 2015 10:34:43 AM

132079

Page 1

Item ID: D4044-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Rib

Start Date: 4/27/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/27/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MCS Date: 15-04-24 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4044	A								
100		0.00							
100									
Large Fab									
Large Fab	Memo	0.00							
	1- Cut tube 60" and remove identification markings								
	2- Bend tube with manuel pipe bender as per template DT9579 (Make first line at 15.00")								
	3- Trim access tube material to finish size as per dwg D4044								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC									
Quality Control	Memo	0.00							
120	Identify as per dwg & Stock Location: <u>WWA 09</u>	0.00							
120									
Packaging									
Packaging	Memo	0.00							

DAS
43
9-89
APR 28 2015DAS
24
9-89
APR 28 2015DAS
43
9-89
APR 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																													
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Work Order ID 132079

Friday, April 24, 2015 10:34:43 AM

132079

Page 2

Item ID: D4044-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Rib
Start Date: 4/27/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/27/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21 - Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MCS APR 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																					

Picklist Print

Friday, April 24, 2015 10:34:42 AM

Page 1

Work Order ID: 132079

132079

Parent Item: D4044-5

D4044-5

Parent Item Name: Aft Rib

Start Date: 4/27/15

Required Date: 4/27/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC IPP Rev:B as per
dwg revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased		No		100	f	1,134.575	5	6			
M304TS0 750W 049										**	DAS 43	APR 29 2015	
304 SQ Tube .75x.75x.049W											9-89		

Location

Loc Qty

Loc Code

WA004

1134.575

M130871

89.4

M131128

450.175

M131868

595

5 feet

DQA: _____ Date: _____

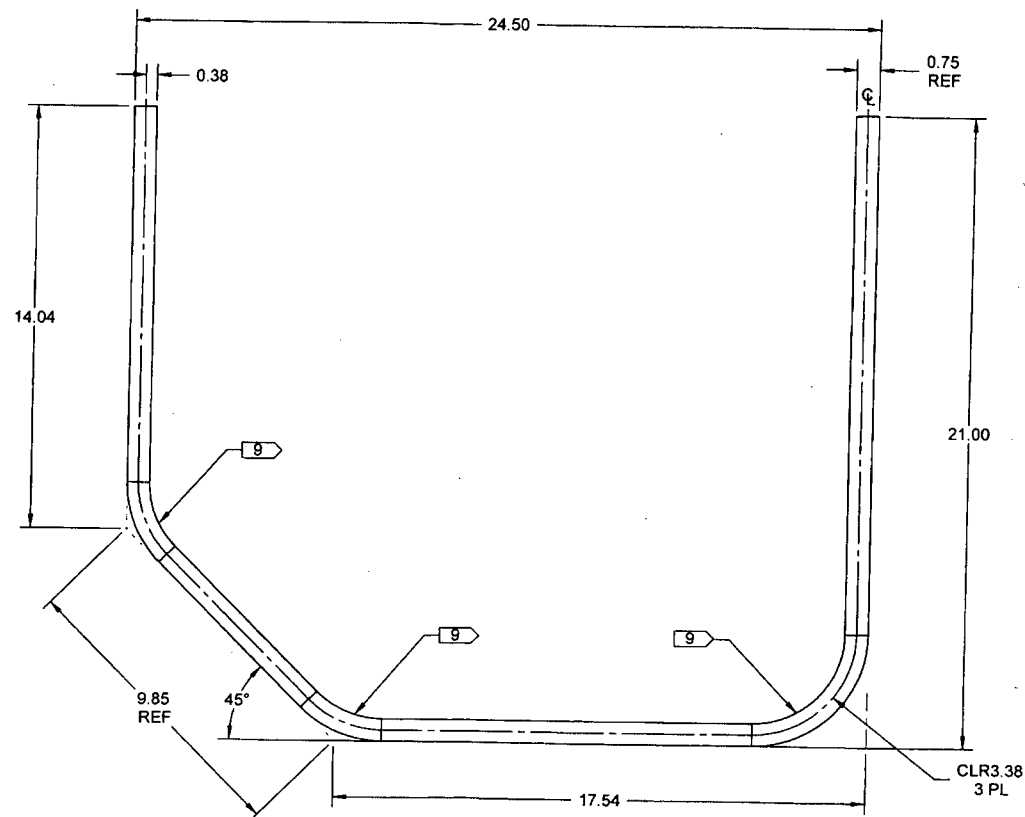


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause		FAULT CATEGORY			
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OTHER : ☐					



SHO...

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132079.MCS
150424

D4044-5 AFT RIB

RELEASED
2010-02-16

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.750 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.21 lbs
- 8) TUBE FLAT LENGTH 59.31 REF
- 9) ALLOWABLE WRINKLING IN BENDS UP TO 0.15" DEEP MAX

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. A
MFG. APPR.	15	D4044	SHEET 5 OF 5
APPROVED	12	TITLE	SCALE
DE APPR.	14	RIB ASSEMBLY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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